

Work Order ID 60368

July 6, 2010 2:57:37 PM



Page 1

Item ID: D3782-045

Accept



Setup Start



Revision ID:

Item Name: Back Leg Assembly

PO7



Stop



Start Date: 7/06/10 Start Qty: 6.00



Cust Item ID:

Required Date: 7/20/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 10/7/10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3782

Rev B

100

Pick Kit



0.00

Packaging

Memo

0.00

SD 10/07/23

7

110



Small Fab

0.00

Small Fab

Memo

0.00

DB 10/07/23

7

120



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

SD 10/07/23

7

Quality Control

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60368

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Page 2

Item ID: D3782-045

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Setup Start



Revision ID:

Item Name: Back Leg Assembly

Stop



Start Date: 7/06/10 Start Qty: 6.00



Cust Item ID:

Required Date: 7/20/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

130

Operation
DescriptionIdentify as per dwg & Stock Location 256Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

10-7-23 708

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/07/26/08
MF

10-7-23

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 60368



Parent Item: D3782-045



Parent Item Name: Back Leg Assembly

Start Date: 7/06/10

Required Date: 7/20/10

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-06-17 rev.A as per dwg DD verified by:EC IPP Rev:C
10.02.22 revB as per dwg DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3772-1 		Manufactured	No			110	Each	15.0000		1	6		
Back Leg													
D3787-1 		Manufactured	No			110	Each	34.0000		1	6		
Foot													
D3764-1 		Manufactured	No			110	Each	10.0000		1	6		
Back Leg Fitting													
D3773-041 		Manufactured	No			110	Each	1.0000		1	6		
Headrest Assembly													

Location Loc Qty Loc Code
ST254 15
54341 12
54374 B56860 3
ST249A 34
46597 2
55763 32
ST248A 10
54340 10
ST249 1
57448 1
B 60384 1

34 2 3
7 6
107 6
1 6
80 10/07/23
80 10/07/23
80 10/07/23
80 10/07/23

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 60368



Parent Item: D3782-045

Parent Item Name: Back Leg Assembly

D3786-1



Sleeve

Manufactured No

110 Each

Start Date: 7/06/10

Start Qty: 6.00

Required Date: 7/20/10

Required Qty: 6.00



SB 10/07/23

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST248A	3	
44533	3	
ST249A	4	
59224	4	

3
4
6

AN45-15A



EYE BOLT

Purchased No

110 Each

20.0000



SB 10/07/23

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST362	20	
109091	10	
114523	10	

107
6

AN5-15A



Bolt

Purchased No

110 Each

64.0000



SB 10/07/23

AN5-17A



Bolt

Purchased No

110 Each

127.0000



SB 10/07/23

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST338	64	107
114941	64	159

107
6

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST339	127	
114330	81	
114784	46	

107
SB 10/07/23

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

Work Order ID: 60368

Parent Item: D3782-045

Parent Item Name: Back Leg Assembly

AN4-15A



Bolt



Start Date: 7/06/10

Start Qty: 6.00

Required Date: 7/20/10

Required Qty: 6.00

Purchased No 110 Each

391.0000 2 12

MS21042L4



Nut

Purchased No 110 Each

4,422.000 2 12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST358	391	
114784	91	
115108	300	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	4410	
113422	68	
114523	28	
114718	314	
114784	2000	
115108	2000	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST356	12	
108145	12	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST139	463	
114813	463	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST351	20	MU115002
108827	20	

Sb 10/07/23

Sb 10/07/23

Sb 10/07/23

Sb 10/08/23

MS21042L5



Nut

Purchased No 110 Each

463.0000 3 18

AN960JD416



Washer

NAS1149D0463J Purchased

No

114813 110 Each

20.0000 4 24

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Page 3

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 60368



Parent Item: D3782-045



Parent Item Name: Back Leg Assembly

AN960JD516



NAS1149D0563J Purchased

No

110

Each

0.0000

5

30

Start Date: 7/06/10

Start Qty: 6.00

Required Date: 7/20/10

Required Qty: 6.00

Washer

M114742



35

SB

10/07/23

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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

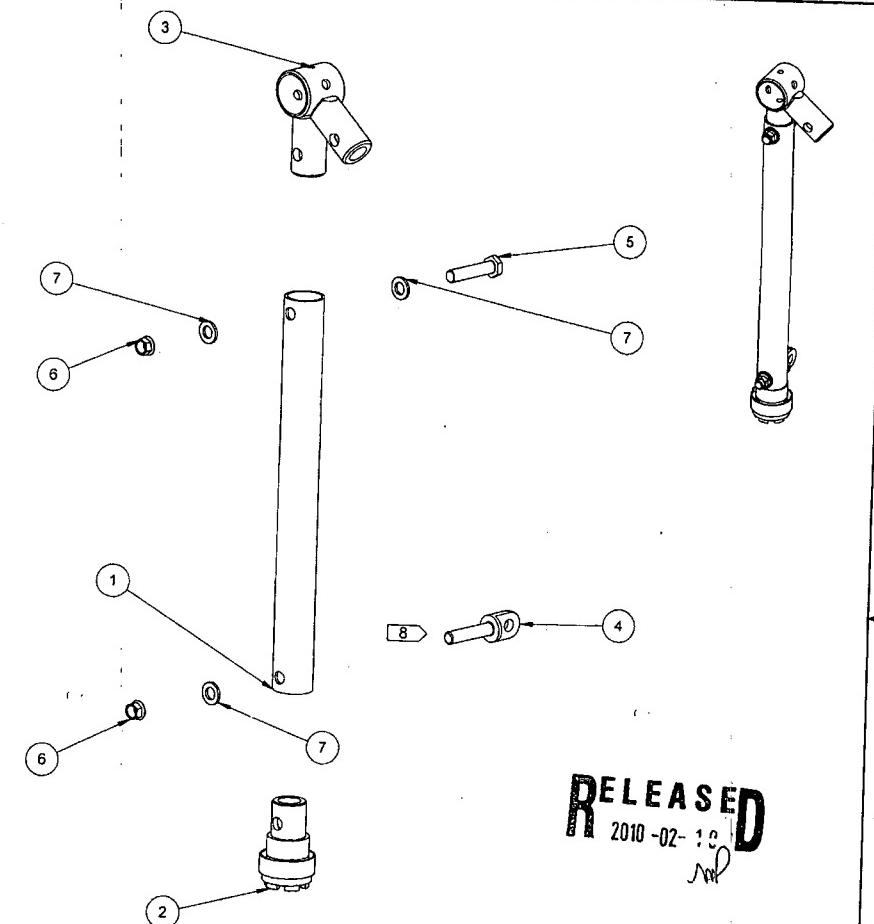
NOTE: Date & initial all entries

ITEM NO.	QTY. (-041)	PART NUMBER	DESCRIPTION
1	1	D3768-1	FRONT INBOARD LEG
2	1	D3787-1	FOOT
3	1	D3762-041	FRONT LEG FITTING ASSY
4	1	AN45-13A	EYE BOLT
5	1	AN5-13A	BOLT
6	2	MS21042L5	NUT
7	3	NAS1149D0563J	WASHER (AN960JD516)

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NO. 60368

CZ01716

D3782-041 FRONT INBOARD LEG ASSEMBLY



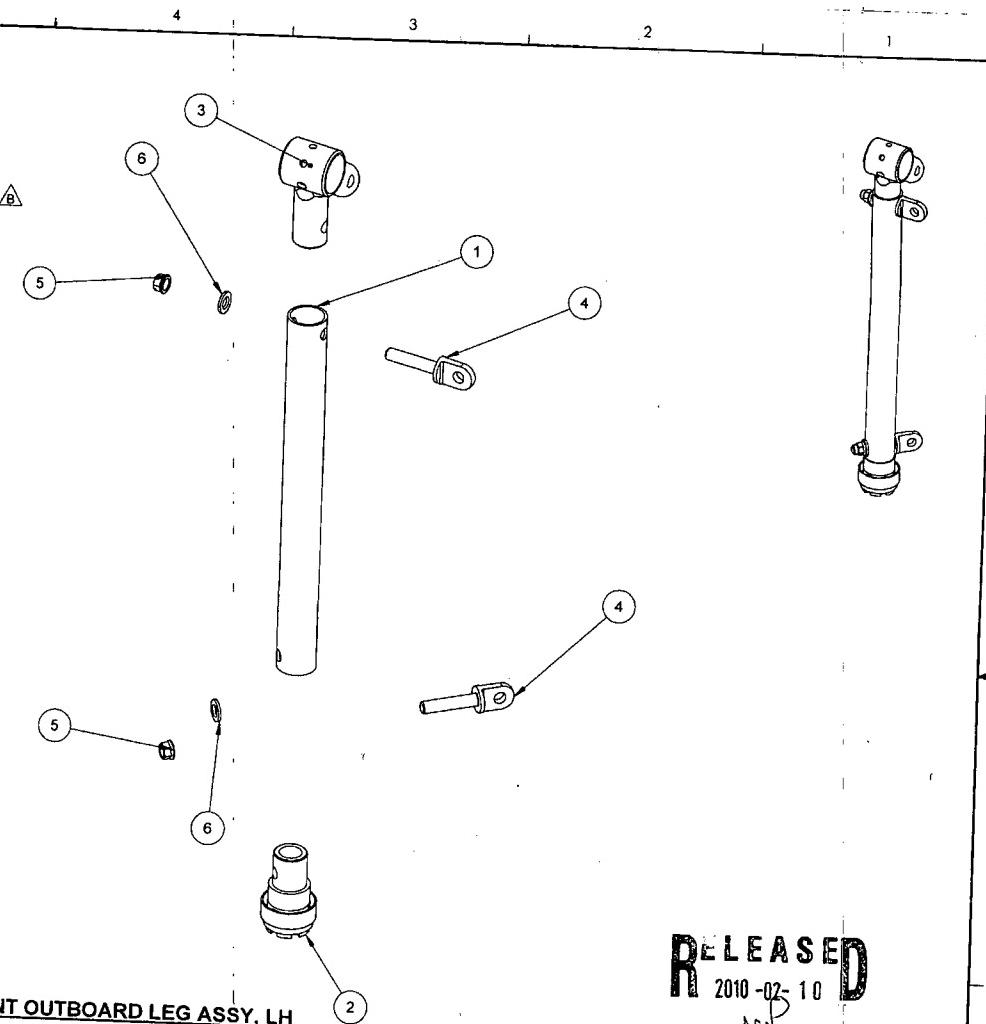
RELEASED
2010-02-16
M

- NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.42 lbs
 8) ITEM 4 (AN45-13A EYE BOLT) INSTALLED AS SHOWN FOR D412-769-041 AFT FACING SEAT, LH
 INSTALLED IN REVERSE FOR D412-769-042 AFT FACING SEAT, RH

B	REVISE P/N NAS1149D0568J TO NAS1149D0563J ALL SHEETS, ZN D7	15	10.01.21
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	BB	DART AEROSPACE LTD	
DRAWN	BB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BB	DRAWING NO.	
MFG. APPR.	DA	D3782 REV. B	
APPROVED	149	TITLE	
DE APPR.	149	SCALE	
DATE	10.01.21	NTS	

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ITEM NO.	QTY. (-043)	PART NUMBER	DESCRIPTION
1	1	D3768-3	FRONT OUTBOARD LEG, LH
2	1	D3787-1	FOOT
3	1	D3762-041	FRONT LEG FITTING ASSY
4	2	AN45-13A	EYE BOLT
5	2	MS21042L5	NUT
6	2	NAS1149D0563J	WASHER (AN960JD516)



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2010-02-10
MM

D3782-043 FRONT OUTBOARD LEG ASSY, LH

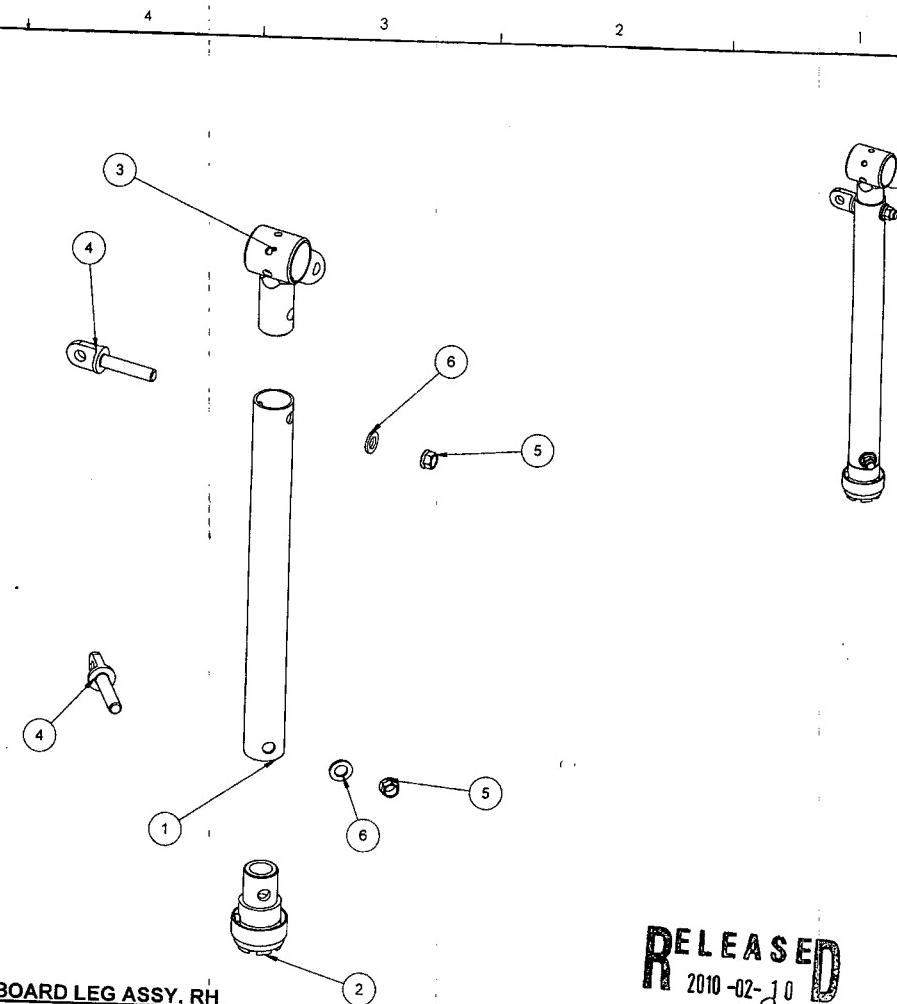
- NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.42 lbs

DESIGN	RE	DART AEROSPACE LTD
DRAWN	RE	HAWKESBURY, ONTARIO, CANADA
CHECKED	RE	
MFG. APPR.	RE	
APPROVED	RE	
DE APPR.	RE	
DATE	10.01.21	SCALE NTS
DRAWING NO. D3782 REV. B TITLE LEG ASSEMBLY SHEET 2 OF 4 COPRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

ITEM NO.	QTY. (-044)	PART NUMBER	DESCRIPTION
1	1	D3768-4	FRONT OUTBOARD LEG, RH
2	1	D3787-1	FOOT
3	1	D3782-041	FRONT LEG FITTING ASSY
4	2	AN45-13A	EYE BOLT
5	2	MS21042L5	NUT
6	2	NAS1149D0563J	WASHER (AN960JD516)

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NO. 60368

D3782-044 FRONT OUTBOARD LEG ASSY, RH



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2010-02-10
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- NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 0.42 lbs

DESIGN	<u>01</u>	DART AEROSPACE LTD
DRAWN	<u>01</u>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<u>B</u>	DRAWING NO.
MFG. APPR.	<u>M</u>	D3782
APPROVED	<u>10</u>	REV. B
DE APPR.	<u>10</u>	SHEET 3 OF 4
DATE	10.01.21	TITLE
		SCALE
		NTS

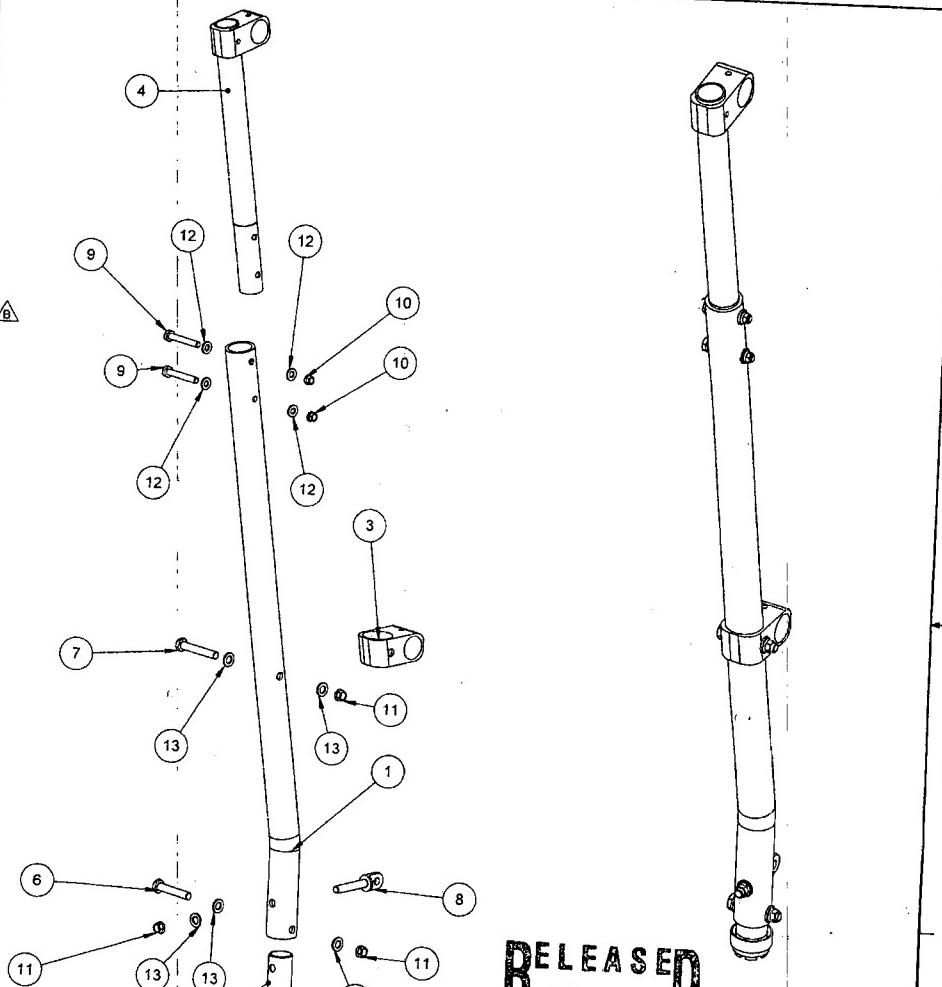
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ITEM NO.	QTY. (-045)	PART NUMBER	DESCRIPTION
1	1	D3772-1	BACK LEG
2	1	D3787-1	FOOT
3	1	D3764-1	BACK LEG FITTING
4	1	D3773-041	HEAD REST ADAPTER ASSY
5	1	D3786-1	SLEEVE
6	1	AN5-15A	BOLT
7	1	AN5-17A	BOLT
8	1	AN45-15A	EYE BOLT
9	2	AN4-15A	BOLT
10	2	MS21042L4	NUT
11	3	MS21042L5	NUT
12	4	NAS1149D0463J	WASHER (AN960JD416)
13	5	NAS1149D0563J	WASHER (AN960JD516)

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WORK ORDER
NO. 60368

D3782-045 BACK LEG ASSY

- NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 4.71 lbs



RELEASED
2010-02-10

DESIGN	<u>RE</u>	DART AEROSPACE LTD	
DRAWN	<u>RE</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>RE</u>	DRAWING NO.	
MFG. APPR.	<u>RE</u>	D3782 REV. B	
APPROVED	<u>RE</u>	SHEET 4 OF 4	
DE APPR.	<u>RE</u>	TITLE	
DATE	10.01.21	SCALE	
		NTS	
LEG ASSEMBLY			

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